

Date: Wednesday, 28/05/2008 2:30:47 PM
User: Linda Lacelle

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING ASSEMBLY
Job Number : 39540
Estimate Number : 10181
P.O. Number : Part Number : D2153
This Issue : 28/05/2008 S.O. No. : Drawing Number : D2153 REV. A1
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : PURCHASED PARTS Drawing Revision : A1
Previous Run : 36845 Material :
Written By : Due Date : 02/06/2008 Qty: 36 Um: 20 Each
Checked & Approved By :
Comment : Est: E 02.07.08 Re-format KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 6454

C 28/05/28

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

20
36

2.0 D2153P Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
GAS SPRING ASSEMBLY

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

Pd/c 36

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

S 08/06/09 36

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Drawing Name: GAS SPRING ASSEMBLY

Job Number: 39540

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Locknut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

B37840

EB 08/06/09

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

M107534

EB 08/06/09

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

M106939

EB 08/06/09

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

EB 08/06/09 (36)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/09 (436) counts

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 439

AS 08/06/09 (436)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 39540

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



c 208/06/109

attwood

-2290

SWIVL-EZE

COLLECT

151793240

DART AERO LTD.
05/30/08PRO NO: 778104323
SHIP VIA: FEDEX GROUND
BOL: 00226970001125278

FREIGHT: _____

WOOD / SWIVL-EZE

1014 NORTH MONROE
JEWELL

MI 49331-0260

DART AERO LTD.
107 ABERDEEN STREET

WYBESBURY ON K6A 1K7

PD#: 6454

DATE: 05/30/08

SPUR: 8

LABEL NO:
4493440001

LITING GUIDE INFO --

EPED--

QTY	LOCATN	UM	PART# / UPC	DESCRIPTION / SKU	ORDER LINE QTY	WGT
36	Z09211	EA	SL13-10-1	GS SPRNG 15" EXTC 10# BL	1	36 12

COMPLETE =====

PICK BY: _____

PAGE: 1 (ONLY PAGE)

**Purchase Order**

Date May 28, 2008	Page 1
Purchase Order Number PO00006454	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

RECEIVED
FAXED
6/28/05/29

REVISED

Vendor Address:

Attwood
1016 North Monroe St
Lowell, MI 49331
USA
Phone (616) 897-2370
Fax (616) 897-8358

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-ATT001	May 28, 2008	N30	Fedex	Jun 06, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
36.0000	D2153P	Door Prop Comments: AS PER DWG D2153 REV. A1 P/N: SL13-10 (10LB) B39540	6/6/2008	No	6.440000	Each	231.84

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:

REVISED:
QTY

Tax Summary:

Entered By: *CL* CLAVOIE

Approved By: *W*

Less:

included tax

0.00

Subtotal

231.84

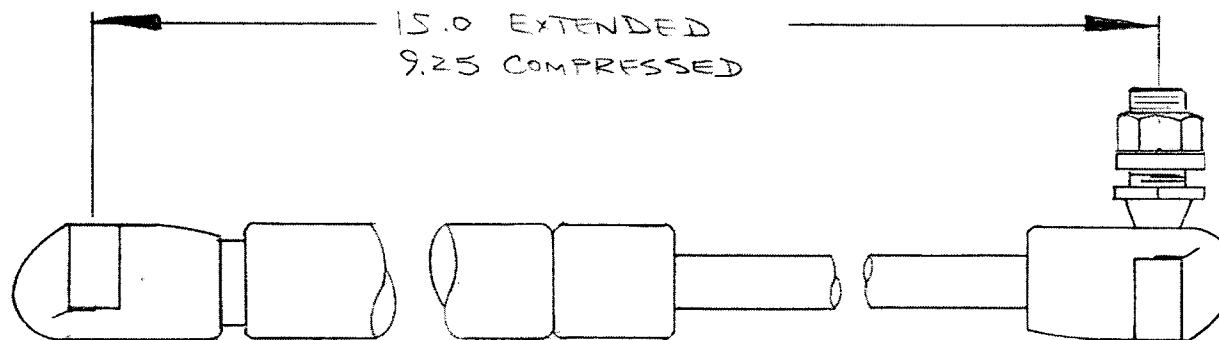
Total tax

0.00

Total purchase order in

USD Dollars

231.84



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39540

SL-13-10 SPRING (SPRING LIFT CORP)

SL69-BS STUD (SPRING LIFT CORP)

AN 960-516 WASHER

~~5/16-18 UNC~~ SELF LOCKING NUT
D3015-3 **A1**

RELEASED
96/07/16

A1 CHANGE TO D3015-3 SL 13-10 WAS SL 32-15		REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE DIA. DASH NO. W-HEAD NEAR SIDE F-HEAD FAR SIDE D-DIMPLE D-DIM NO. OF SHEETS C-COUNTERSINK LENGTH DASH NO. W-SPOTWELD BASIC CODES BU-M520470AD BU-M520470AD	PART NO. CONTRACT NO. DRAWN HATTON DATE 07.28.72 DESIGN HATTON STRESS CHECKED CLERK	DESCRIPTION GAS SPRING ASSEMBLY	MATERIAL DART AERO ACCESSORIES INC. VANCOUVER CANADA	SPEC./VENDOR DART AERO ACCESSORIES INC. VANCOUVER CANADA
01.05.01 CHANGE TO D3015-3 SL 13-10 WAS SL 32-15		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 7742 5. HOLES PER AND 10067 LIMITS 1. TOLERANCES - .001 ± .003 2. ANGLES .010 3. PARALLELISM .0025 4. ECCENTRICITY .001 MAX 5. STYRENE EPT ABOUT ALL MAX CENTRE LINES .005	REPORT ALL DISCREPANCIES - DO NOT SCALE	DOW NO DZ153 SCALE 1:1 SHT 1 OF 1	REV A			

DZ153